

## CLAIMS

What is claimed is:

- 1           1.     A folding roll for a folding apparatus, said folding roll comprising:  
2                 at least one cylindrical surface having at least one frictional area to which  
3     frictional material has been applied by thermal spray coating, said at least one frictional  
4     area being bounded by deeper areas to which no friction material has been applied.
- 1           2.     A folding roll as in claim 1 wherein said at least one frictional area  
2     comprises a plurality of four-corned frictional areas.
- 1           3.     A folding roll as in claim 1 wherein said at least one frictional area  
2     comprises a strip of frictional material running spirally around said cylindrical surface.
- 1           4.     A folding roll as in claim 1 wherein said at least one cylindrical  
2     surface comprises a plurality of cylindrical surfaces separated by circumferential  
3     channels for tape lines, each said circumferential channel having a circumferential  
4     surface provided with at least one frictional area to which frictional material has been  
5     applied by thermal spray coating.
- 1           5.     A folding roll as in claim 1 wherein said frictional material has a  
2     depth of about 0.3 mm on said frictional areas.
- 1           6.     A folding roll as in claim 2 wherein said folding roll comprises part  
2     of a third longitudinal folding apparatus.

1                   7.     A folding roll as in claim 3 wherein said folding roll comprises part  
2 of a folding former.

1                   8.     A method of producing a folding roll for a folding apparatus, the  
2 method comprising:

3                   fitting a mask to at least one cylindrical surface, said mask having cutouts  
4 shaped and arranged to correspond to the shape and arrangement of desired frictional  
5 areas on said at least one cylindrical surface;

6                   applying a frictional material by means of thermal spray-coating to said  
7 mask and said at least one cylindrical surface via said cutouts; and

8                   removing said mask.

1                   9.     A method as in claim 8 wherein said mask is provided with  
2 longitudinal edges, said mask being fitted to said at least one cylindrical surface so that  
3 said longitudinal edges form a butt joint.

1                   10.    A method of producing a folding roll for a folding apparatus, the  
2 method comprising:

3                   winding a strip-like mask around a cylindrical surface spirally to form turns  
4 separated by a gap corresponding to a frictional area extending spirally around said  
5 cylindrical surface;

6                   applying a frictional material by means of thermal spray-coating to said  
7 mask and said at least one cylindrical surface via said gap; and

8                   removing said mask.